

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 EXTRUSION BENDING
Job Number	: 34692		
Estimate Number	: 10311		
P.O. Number	: N/A	Part Number	: D2620
This Issue	: 9/17/2007 S.O. No. : N/A	Drawing Number	: D2620 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 33880	Material	: N/A
Written By	: [Signature]	Due Date	: 9/24/2007 Qty: 30 Um: Each
Checked & Approved By	: [Signature] 07.09.17		
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Job Number:



1.0	D26001160	Extrusion Round 3" 206
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Extrusion Round 3" 206

Qty	Part Number
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1 D2600-1 Extrusion Round 3"206

Batch

30297

SR

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Foljo Ft008

2- Cut Fwd end of tube as per Dwg D2620

EL/SR/AWM
07/09/18

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 7-9-18

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

#1 DP 7-9-18

30

5.0 QC21 FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

07/09/15

Job Completion



CL07/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

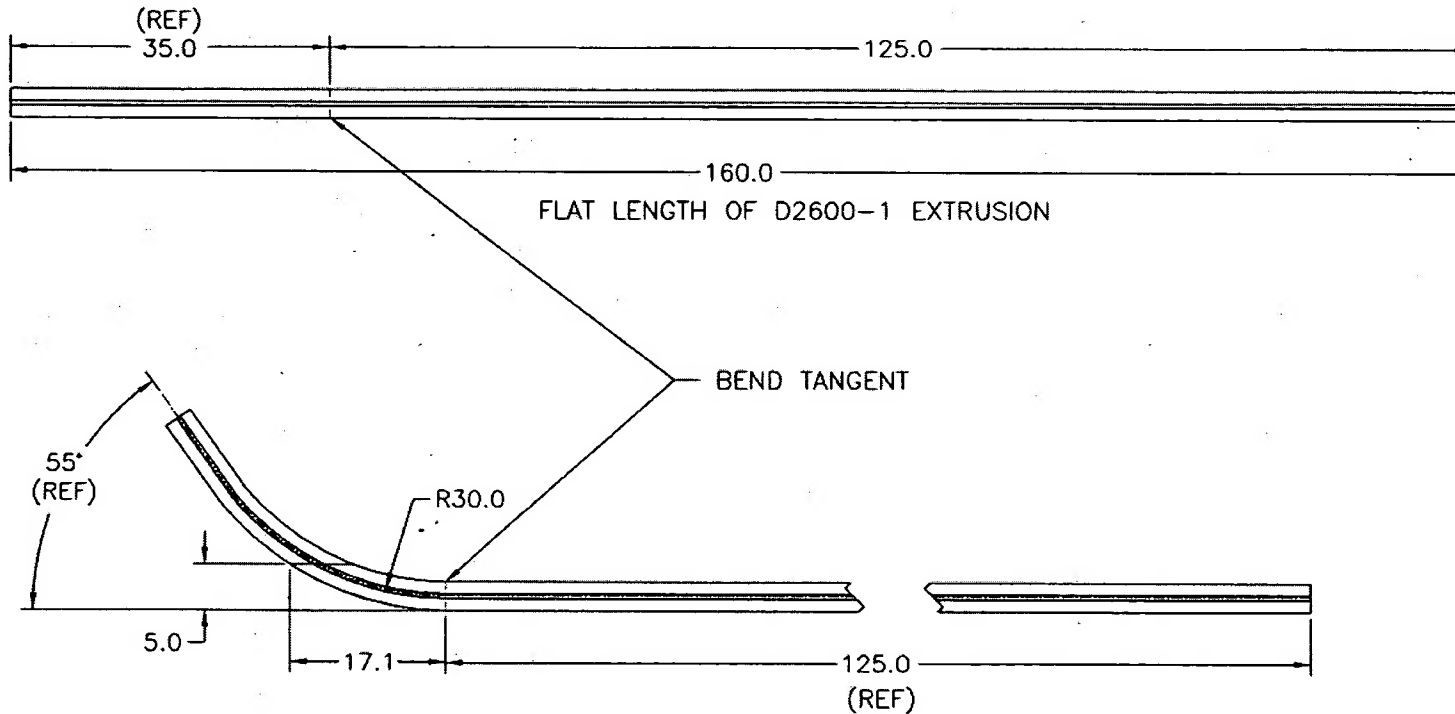
Part No: D2620 PAR #: N/A Fault Category: Prod/Landing Gear NCR: Yes No DQA: D Date: 07/09/19
 QA: N/C Closed: D Date: 02.09.19

NCR: <u>34692</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07-09-18</u>	<u>1.0</u>	<u>1 Lbe was found with a big dent on the top. VERY visible.</u>	<u>[Signature]</u> <u>02/09/18</u>	<u>scraper des top. Replace B30249 Qty 1</u>	<u>[Signature]</u> <u>07-09-18</u>	<u>07-09-18</u>	<u>[Signature]</u>	<u>07-09-18</u>

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

RELEASED
49.04.15 D5

